












Date: Tuesday, 14/10/2008 10:20:03 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT FACING SEAT ASS'Y RH
Job Number	: 42561		
Estimate Number	: 13314		
P.O. Number	:	Part Number	: D412769044
This Issue	: 14/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D412-769-2 REVB
First Issue	: / /	Project Number	: N/A
Previous Run	: 40920	Drawing Revision	: B
Written By	:	Material	:
Checked & Approved By	: <u>JUD 08-10-14</u>	Due Date	: 21/10/2008
Comment	Est rev A 08-05-12 new issue DD verified by:ec Est Rev:B 08-07-17 revB as per dwg DD verified by:ec Est Rev:C 08-08-21 move D3792-1 after powder coat DD verified by:EC		
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Pick Packing Kit			
2.0	D3782045	Back Leg Assembly	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Back Leg Assembly batch: <u>D42152</u>			
3.0	D3782041	Front Inboard Leg Assembly	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Inboard Leg Assembly batch: <u>42149</u>			
4.0	D3782044	Front Outboard Leg Assembly, RH	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Front Outboard Leg Assembly, RH batch: <u>42151</u>			
5.0	D3783041	Lateral Brace Assembly	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Lateral Brace Assembly batch: <u>42125</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/10/2008 10:20:04 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 42561

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 D3783043 Longitudinal Brace Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Longitudinal Brace Assembly
batch: B42640

SP

7.0 D3783045 Angle Brace Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Angle Brace Assembly
batch: B42551

8/10/21

SP

8.0 D3784041 Seat Support Assembly, Center



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, Center
batch: 42641

FF 08/10/23

①

9.0 D3784043 Seat Support Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, LH
batch: 42520

SP

10.0 D3784044 Seat Support Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Seat Support Assembly, RH
batch: 42522

SP

11.0 D37662 Front Rail, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Front Rail
batch: B40864

SP

12.0 D37663 Rear Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Rear Rail
batch: B40865

8/10/21

SP

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 42561

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D37671	Upper Rail
------	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Upper Rail

batch: 40866

50

14.0	AN415A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M108868

8/10/21

50

15.0	AN45 13A	EYE BOLT
------	----------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

EYE BOLT

batch: ~~109013~~ 109013

FF 08/10/23

①

16.0	AN510A	Bolt
------	--------	------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M108990

50

17.0	AN513A	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: M10867

50

18.0	AN960JD10	Washer
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Comment: Qty.: 21.0000 Each(s)/Unit Total : 21.0000 Each(s)

Washer

batch: M109059

(or NAS1149D0363J) batch: _____

50

19.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: M108827

(or NAS1149D0463J) batch: _____

8/10/24

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 42561

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 AN960JD516 Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

batch: M109059

(or NAS1149D0568J) batch: _____

SLP

21.0 AN52510R24 Screw



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Screw

batch: M108879

SO

22.0 MS21042L3 Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

batch: M109031

SLP

23.0 MS21042L4 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: M108145

SLP

24.0 MS21042L5 Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M108827

8/10/24

SLP

25.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble as per dwg D412-769-2

FF 08/10/23

26.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SO 08/10/24

FD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 42561

Part Number: D412769044

Job Number:



Seq. #: Machine Or Operation: Description :

27.0 POWDER COATING POWDER COATING



11106942



Comment: POWDER COATING

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- install bolts in 3 place (in seat belt eye bolt holes) to ensure leg does not move when powder coating

3- Powder coat remaining of assembly grey as per dwg D412-769-2

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 7:30AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 8:00am

FF 08-10-24 (X)

28.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08/10/27

29.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

30.0 D37921 Seat Belt Eye Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Seat Belt Eye Bolt B42563

FF 08/10/29 (1)

31.0 D37751 Guard



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Guard

batch: B40869

JP

32.0 D37741 Seat Bottom, LH/RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Seat Bottom, LH

batch: B40867 B41084

8/10/21

JP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: AFT FACING SEAT ASSY RH

Job Number: 42561

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0	D37743	Seat Back, LH/RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Seat Back, LH/RH

batch: 1541085

50

34.0	AN525 10R22	Screw
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Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

batch: M109267

50

35.0	AN960JD10L	Washer
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Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Washer

batch: M105793

(or NAS1149D0332J) batch:

50

36.0	MS21042L3	Nut
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Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Nut

batch: M109031

50

37.0	AN35A	Bolt
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

batch: M105188

8/10/21

50

38.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install remaining parts as per dwg D412-769-2

FF 08/10/28

①

39.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

508/10/29 (X) RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: AFT FACING SEAT ASS'Y RH

Job Number: 42561

Part Number: D412769044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP42987

JS 08/10/29 (K)

41.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/05 (J)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MR 08-11-04

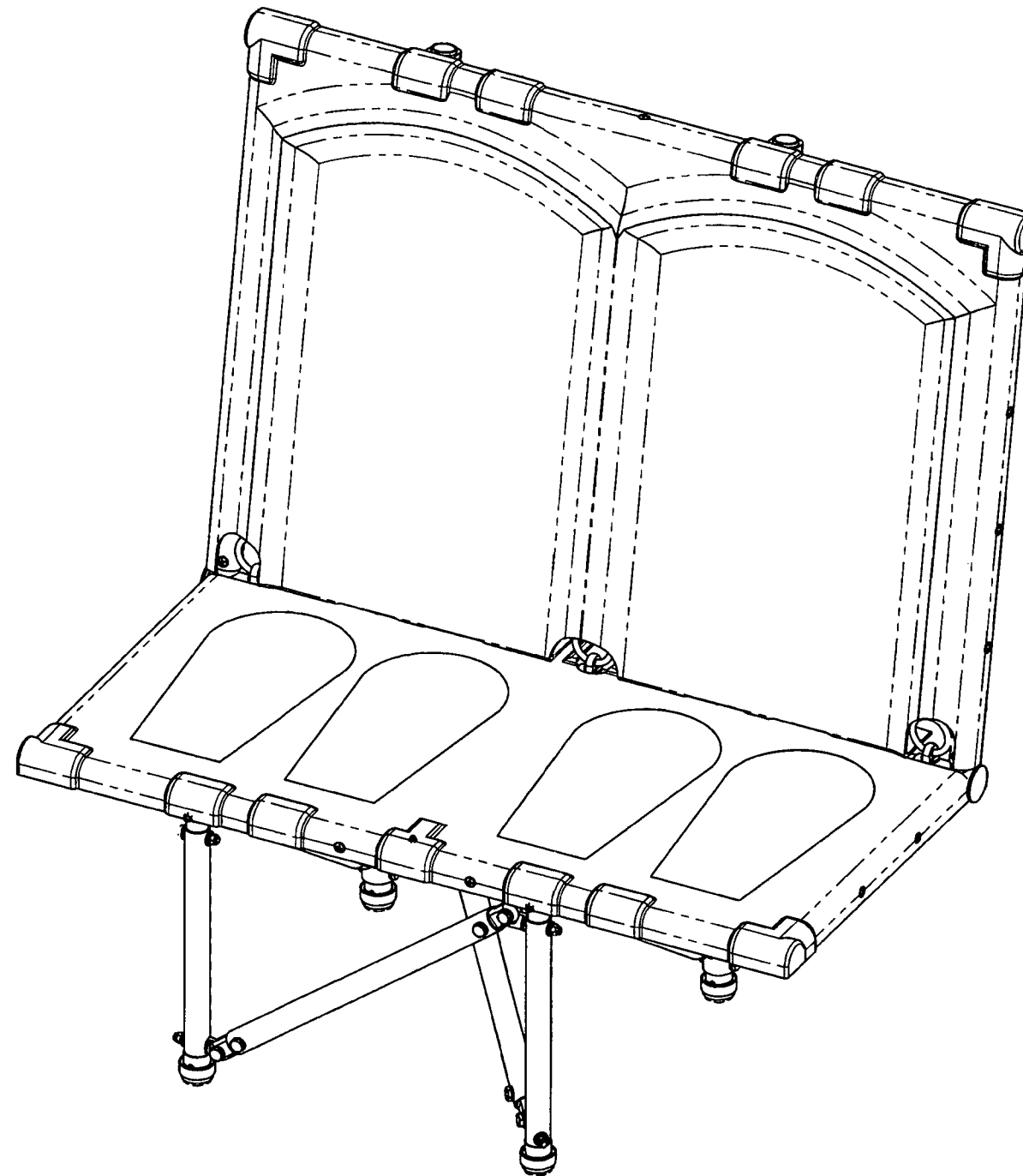
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



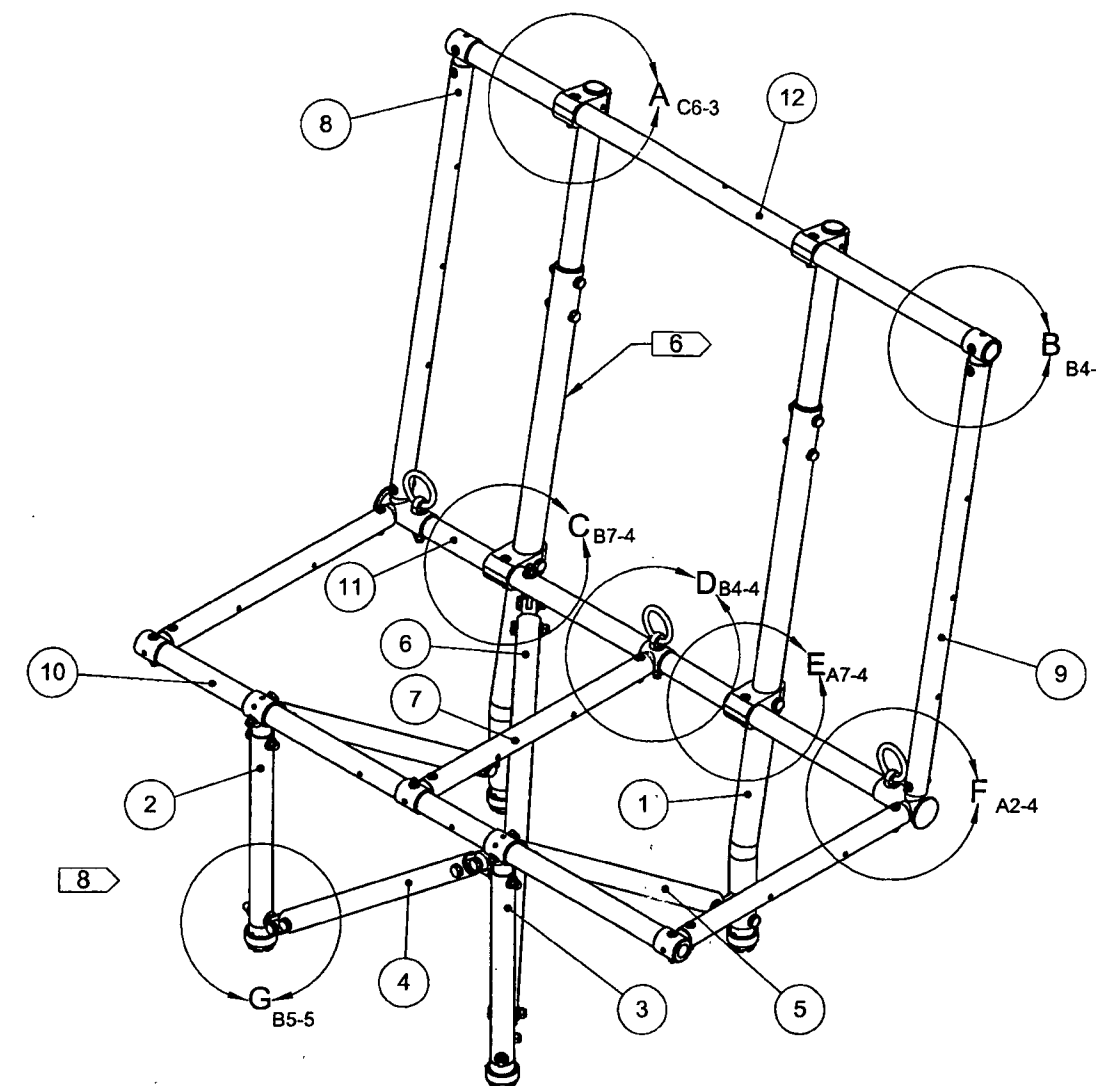
D412-769-044 AFT FACING SEAT, RH

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08.07.10/MP

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WITHOUT NOTICE
WORK ORDER
NO. 4250

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-2	SHEET 1 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, RH	NTS
DATE	08.06.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-044	FRONT OUTBOARD LEG ASSY, RH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-2	FRONT RAIL, RH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20



D412-769-044 AFT FACING SEAT, RH

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08-07-10

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NO. 42561

- NOTES:**
1) MATERIAL: N/A
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1, -3). MASK FRONT LEGS PRIOR TO POWDER COAT
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
7) WEIGHT: 30.0 lbs
8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D412-769-2	SHEET 2 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	AFT FACING SEAT ASSY, RH	NTS
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AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

D3767-1
UPPER RAIL
REF

D3782-045
BACK LEG ASSY
REF

DETAIL A_{D2-2}
UPPER RAIL TO BACK LEG ATTACHMENT
2 PL

D3767-1
UPPER RAIL
REF

AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

D3784-044
SEAT SUPPORT ASSY, RH
REF

DETAIL B_{C1-2}
SEAT SUPPORT END ATTACHMENT (TYP)
5 PL

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D3782-045
BACK LEG ASSY
REF

AN45-13A EYE BOLT (1)
NAS1149D0568J WASHER (1)
MS21042L5 NUT (1)

D3766-3
REAR RAIL
REF

AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

DETAIL C C2-2
REAR RAIL TO BACK LEG ATTACHMENT

AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

D3766-3
REAR RAIL
REF

D3782-045
BACK LEG ASSY
REF

DETAIL E C2-2
REAR RAIL TO BACK LEG ATTACHMENT

D3784-041
SEAT SUPPORT ASSY, CENTER
REF

D3766-3
REAR RAIL
REF

DETAIL D C1-2
SEAT SUPPORT ASSY, CENTER ATTACHMENT

D3792-1 SEAT BELT EYE BOLT (1)
NAS1149D0568J WASHER (2)
MS21042L5 NUT (1)

D3792-1 SEAT BELT EYE BOLT (1)
NAS1149D0568J WASHER (2)
MS21042L5 NUT (1)





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08.07.10

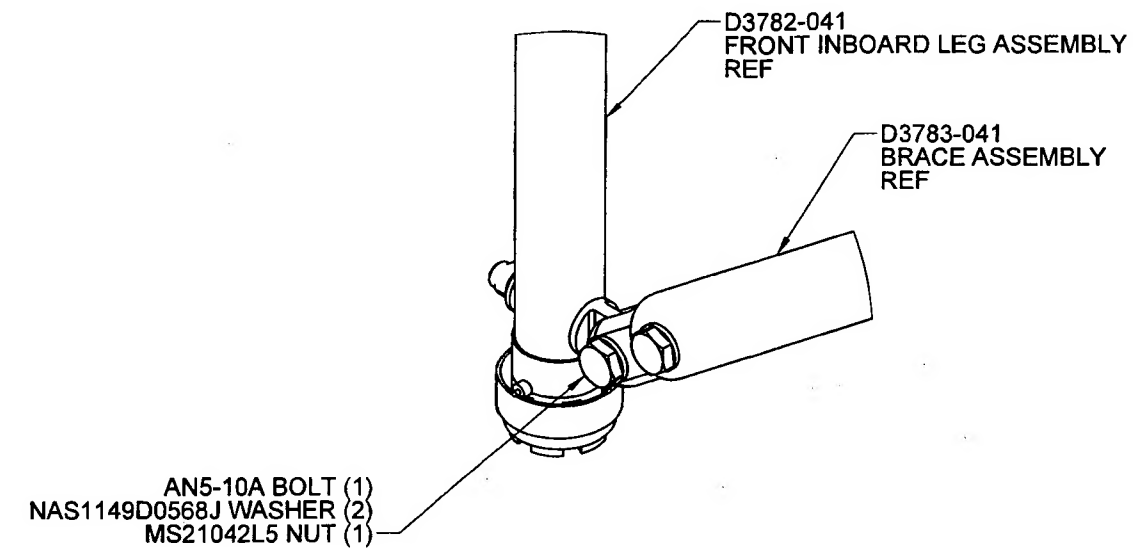
D3775-1
GUARD
REF

D3784-044
SEAT SUPPORT ASSY, RH
REF

DETAIL F B1-2
SEAT SUPPORT ATTACHMENT
2 PL

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WORK ORDER
NO. 42561

DESIGN	HS	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-2	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, RH	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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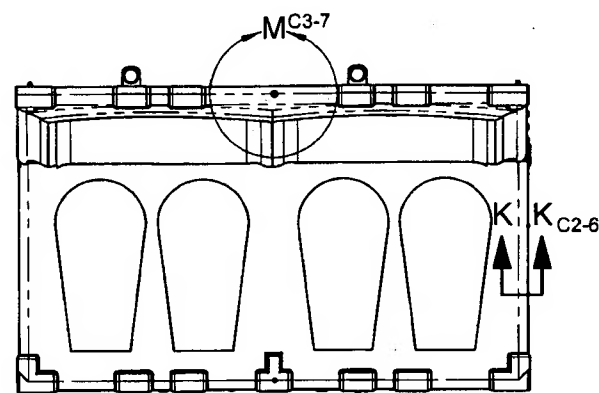


DETAIL G_{B3-2}
BRACE ATTACHMENT
6 PL

RELEASED
08-07-10

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NO. 462361

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D412-769-2	SHEET 5 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
3 PL PER SIDE

D3784-044
SEAT SUPPORT, RH
REF

1

SECTION H-H

B7-6

D3774-3
SEAT BACK
REF

AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
2 PL PER SIDE

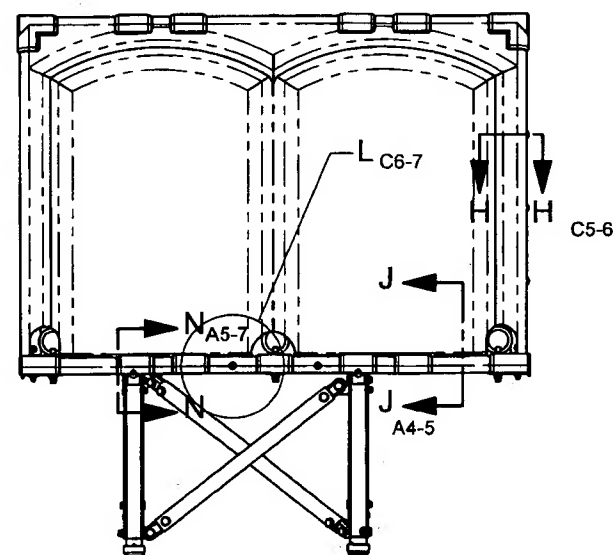
2

SECTION K-K

D7-6

D3774-1
SEAT BOTTOM
REF

D3784-044
SEAT SUPPORT, RH
REF



D3766-2
FRONT RAIL
REF

SECTION J-J B7-6

D3774-3
SEAT BACK
REF

D3774-1
SEAT BOTTOM
REF

D3766-3
REAR RAIL
REF



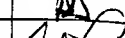

3

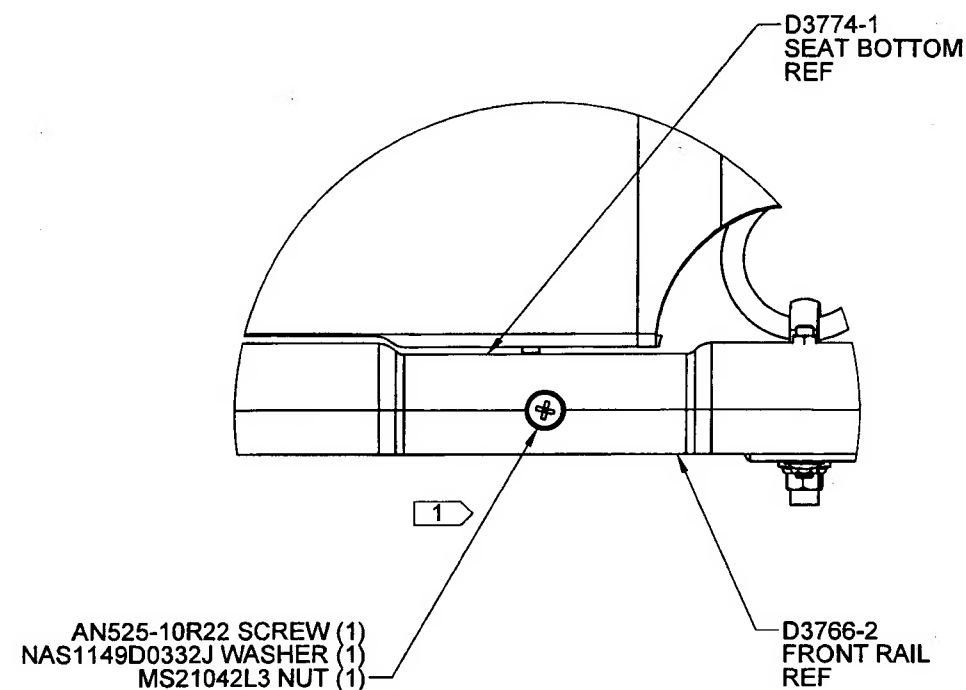
AN3-5A BOLT (1)
NAS1149D0363J WASHER (2)
MS21042L3 NUT (1)
6 PL

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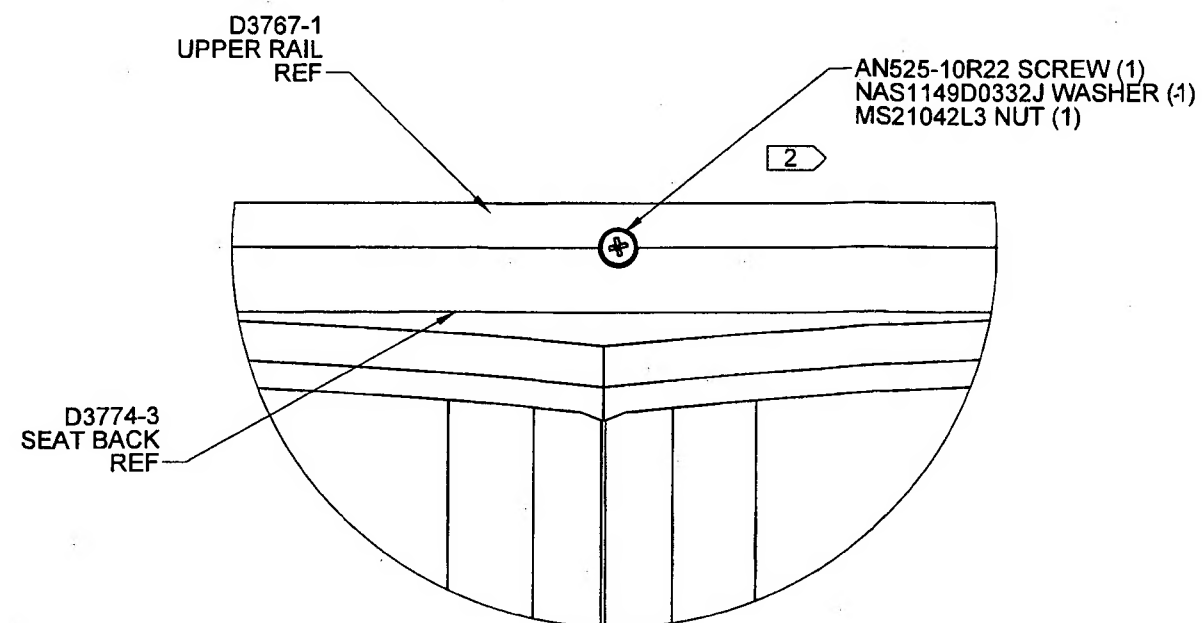
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NO. 42561

- NOTES:
1) TRANSFER DRILL HOLES $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BACK (D3774-3) - 3 PL/SIDE
2) TRANSFER DRILL HOLES $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BOTTOM (D3774-1) - 2 PL/SIDE
3) TRANSFER DRILL HOLES $\varnothing 0.201$ FROM SEAT BOTTOM (D3774-1) TO SEAT BACK (D3774-3) - 6 PL

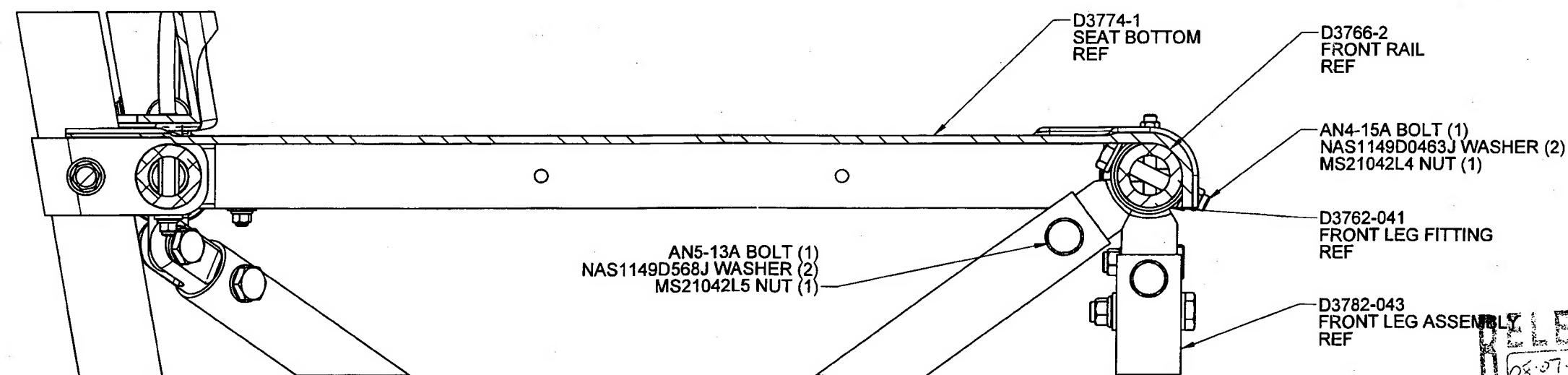
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DETAIL L B7-6
SEAT BOTTOM ATTACH - FRONT DETAIL



DETAIL M D7-6
SEAT BACK ATTACH - TOP DETAIL



SECTION N-N B7-6
FRONT LEG AND LONGITUDINAL ANGLE ATTACHMENT

NOTES:
1) TRANSFER DRILL HOLES $\varnothing 0.201$ FROM FRONT RAIL (D3766-2) TO SEAT BOTTOM (D3774-1) - 2 PL
2) TRANSFER DRILL HOLES $\varnothing 0.201$ FROM UPPER RAIL (D3767-1) TO SEAT BACK (D3774-3) - 1 PL

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DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D412-769-2	SHEET 7 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT FACING SEAT ASSY, RH	NTS
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